

Work Order ID 106613

106613

Page 1

September-10-13 1:36:49 PM

Item ID: D2965 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 9/10/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 9/10/13 Req'd Qty: 2.00 *2* Customer:
 Reference: repaint - *Repair*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2965	Rev B								

150 Powdercoat 0.00
 150 Memo 0.00
 Powdercoat
 Powder Coating
 PULL FROM STOCK:
 2 X D2965 B80089
 SCUFF LIGHTLY - REPOWDER COAT GREY SANDTEX
 Mask as per Dwg D2965 Powder To match Old tube (Ref: 4.3.5.x) as per QSI
 005 4.3 START TIME: 2:40 OVEN TEMPERATURE:
 FINISH TIME: 2:40

2 X P.M. / 13/09/10

W121279

30075

2:40

160 QC3- Inspect Part Finish 0.00
 160 Memo 0.00
 QC
 Quality Control

2 Φ 139-10



Work Order ID 106613

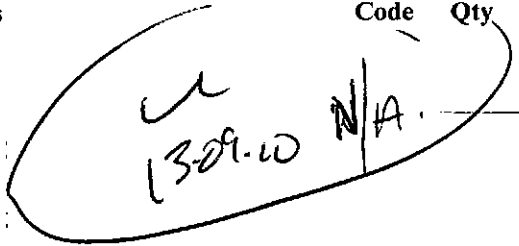
106613

Page 2

September-10-13 1:36:49 PM

Item ID: D2965 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 9/10/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 9/10/13 Req'd Qty: 2.00 *2* Customer:
 Reference: repaint

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* HandFinish Hand Finishing	Hand finishing Memo Install Inserts as per Dwg D2965	0.00 0.00							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-001</u> using new B/N Memo	0.00 0.00							

2x f all 13/09/11

Work Order ID 106613

106613

Page 3

September-10-13 1:36:49 PM

Item ID: D2965 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Cap
Start Date: 9/10/13 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 9/10/13 Req'd Qty: 2.00 *2* Customer:
Reference: repaint

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

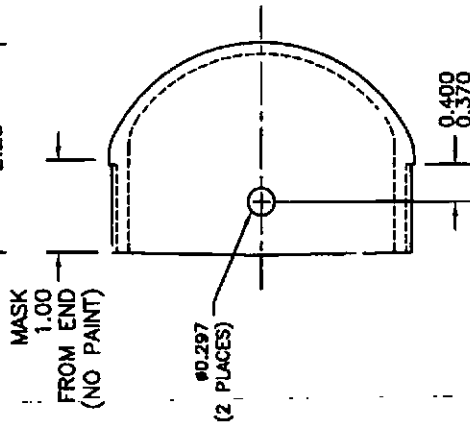
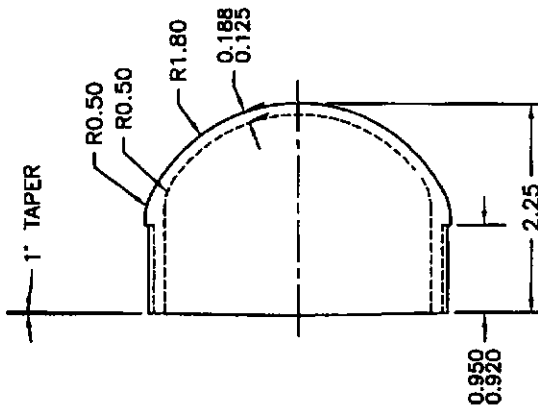
13/9/11

13-09-11

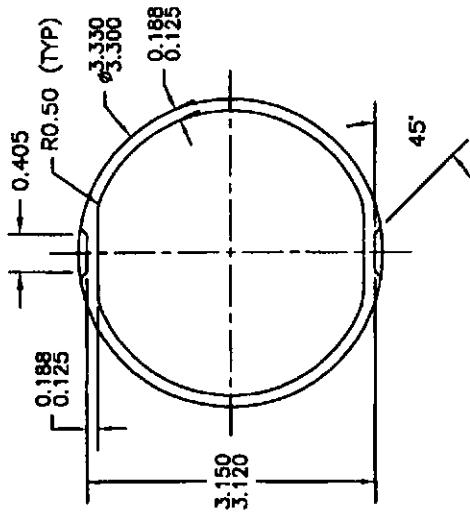
DART**RELEASED**

06.12.12

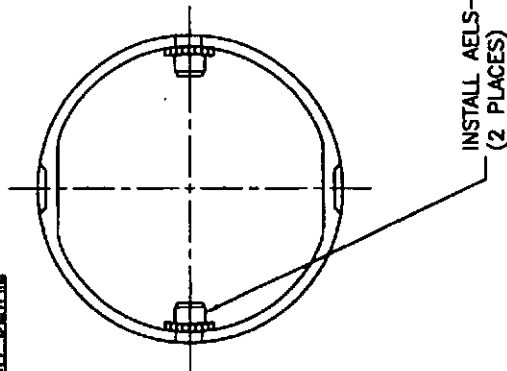
DESIGN PH		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]		DRAWING NO. D2965		REV. B SHEET 1 OF 2
DATE 06.11.01			TITLE CAP SCALE 1:2		
A	00.02.24		NEW ISSUE		
B	06.11.01		ADD -3 CAP		

*who added?*

D2965 CASTING DETAIL



D2965 FINISH DETAIL



- D2965 CAP
- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
 - 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE INCHES

Copyright © 2000 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DESIGN	DRAWN BY	DRAWING NO.	REV.
M	AT	D2965	B
CHECKED	APPROVED		SHEET 2 OF 2
DATE	TITLE	SCALE	
06.11.01	CAP	1:2	

RELEASED

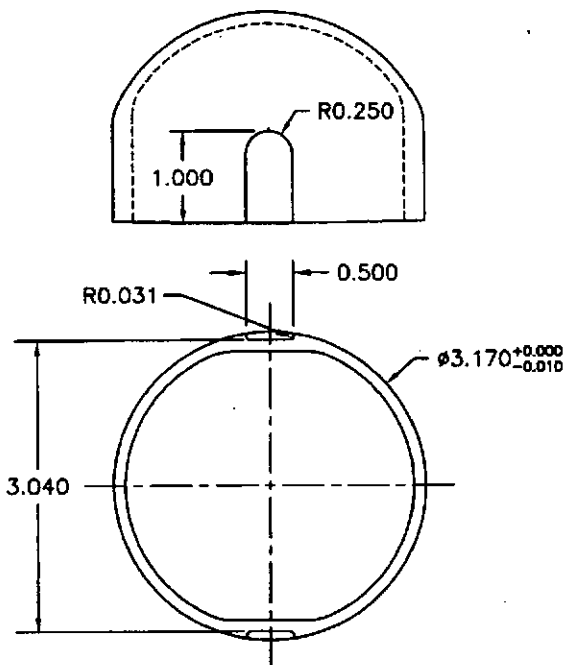
06.11.01

MASK
1.00
FROM END
(NO PAINT)

Ø0.297
INSTALL AELS-1032-130
AFTER FINISH
(2 PLACES)

0.400
0.370

D2965-3 FINISH DETAIL



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

